

Date: Monday, 3/13/2006 7:29:51 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 26206		
Estimate Number	: 10315		
P.O. Number	: N/A	Part Number	: D265635
This Issue	: 3/13/2006 S.O. No. : N/A	Drawing Number	: D2656 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: D
Previous Run	: 25330	Material	: N/A
Written By	: <i>SEE COMMENT BELOW</i>	Due Date	: 3/30/2006 Qty: 50 Um: Each
Checked & Approved By	: <i>06.03.13</i>		
Comment	: Est: D 02.10.25 Re-format KJ/RF		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *890*

1-Email or ship DXF file to vendor

2-Laser Cut per Dwg D2656 flat pattern D2656-35

3-Material release note required

2.0

D265635F

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

WEARPLATE

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2656-35T1

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326. *SAD 06305303*

3-Identify as D2656-35.

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/05/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 7:29:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 26206

Part Number: D265635

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-05-04

(50)

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 05 10

(50)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL

06-05-11

(50)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP 30

DL

06/05/11

(50)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/12

(50)

Job Completion



u 06-05-12

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

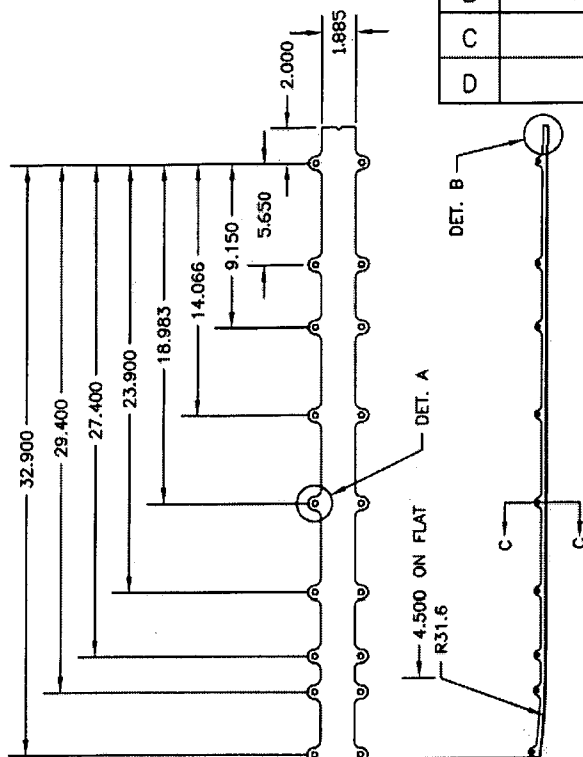
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

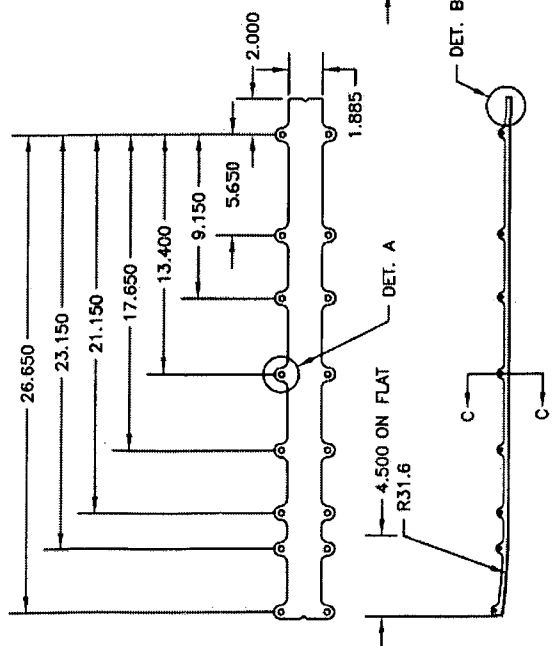


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				PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
				D2656	SHEET 1 OF 4
DATE	05.08.17			TITLE	SCALE
				WEARSHOE	1:10
A	97:03:25	NEW ISSUE			
B	97:06:02	CHANGED TABS			
C	97:06:26	R31.6 WAS R19.5			
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT			

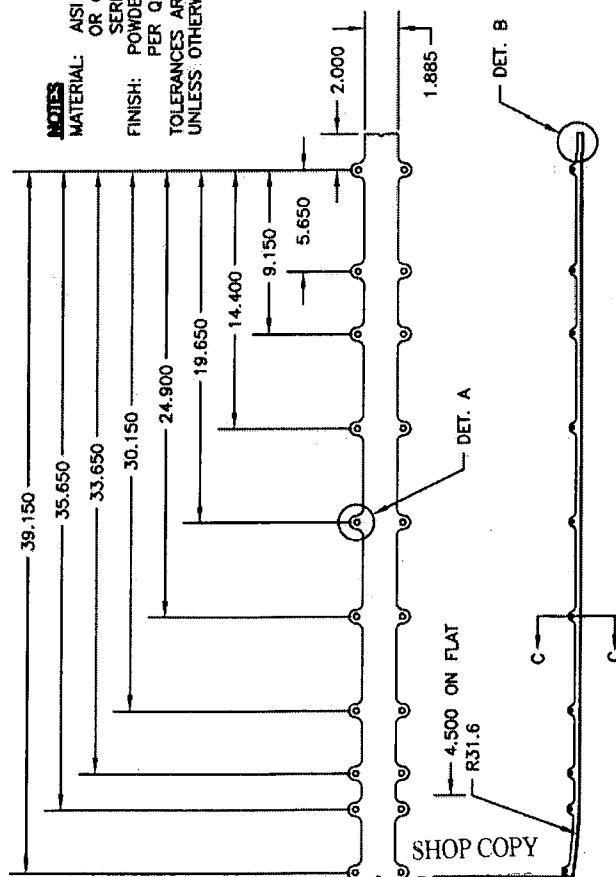
D2656-13



D2656-11



D2656-15



NOTES:
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
 OR CSA C40-21, 38W/44W/50W/60W/70W
 SERIES STEEL 20 GAUGE (0.040 THICK)
 FINISH: POWDER COAT GREY SANITEX (4.3.5.6)
 TOLERANCES ARE PER DART QSI 018
 PER QSI 005 4.3
 UNLESS OTHERWISE NOTED

RELEASED
 05.09.08

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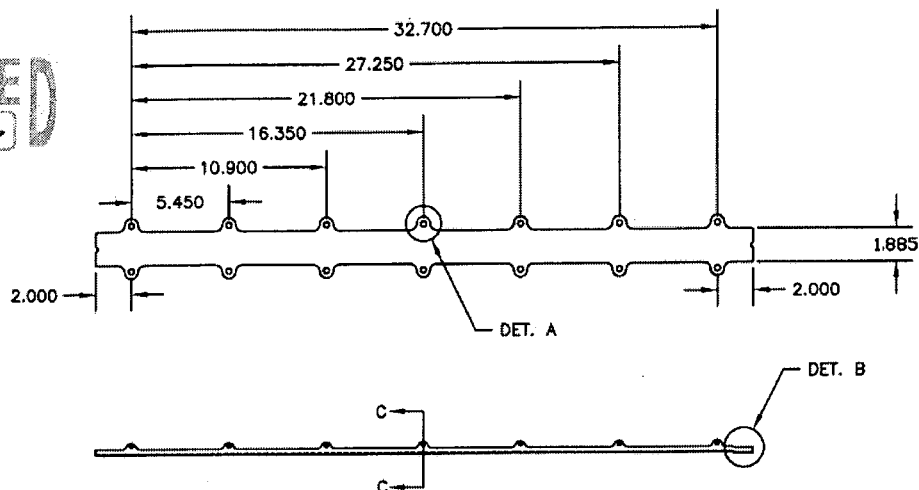
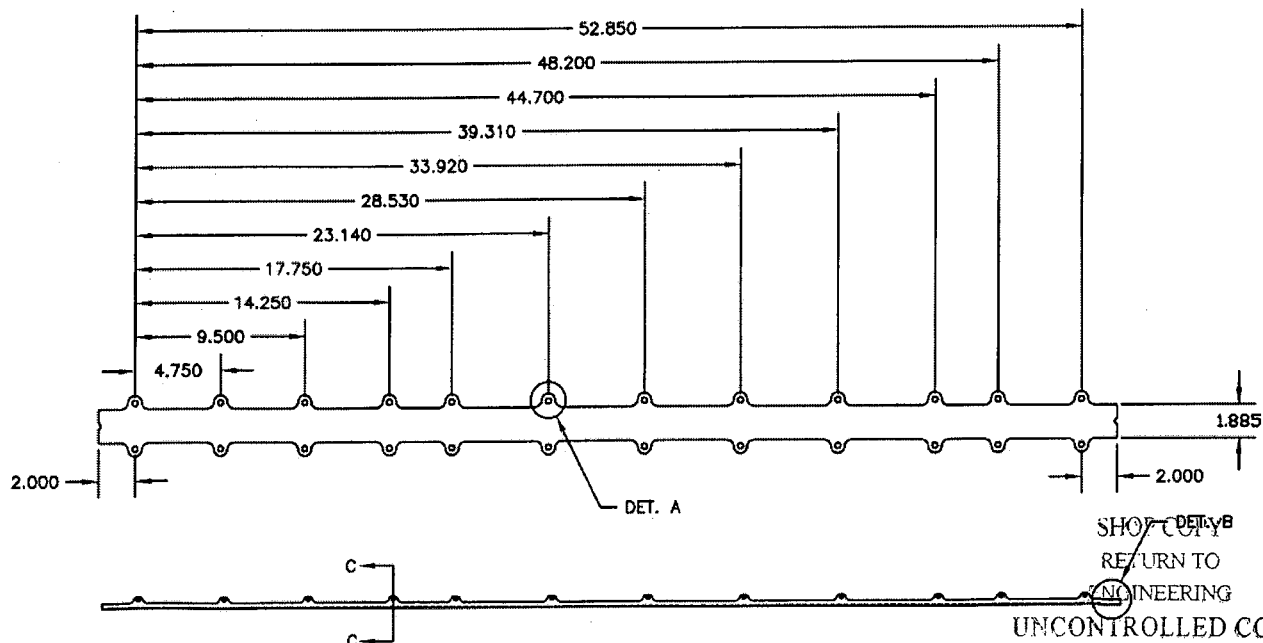
WORK ORDER

NO. 26206

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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

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DS 07.06 *[Signature]*

D2656-21**D2656-23****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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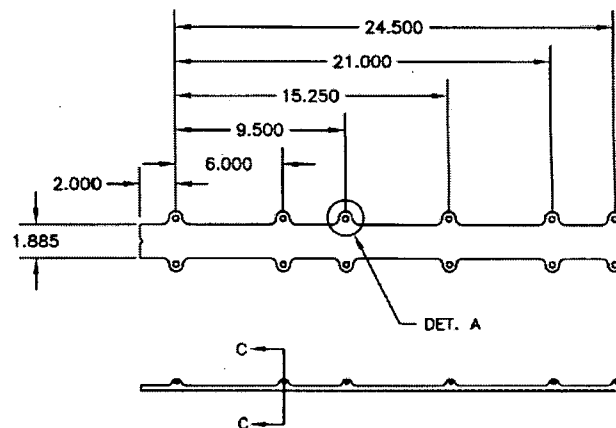
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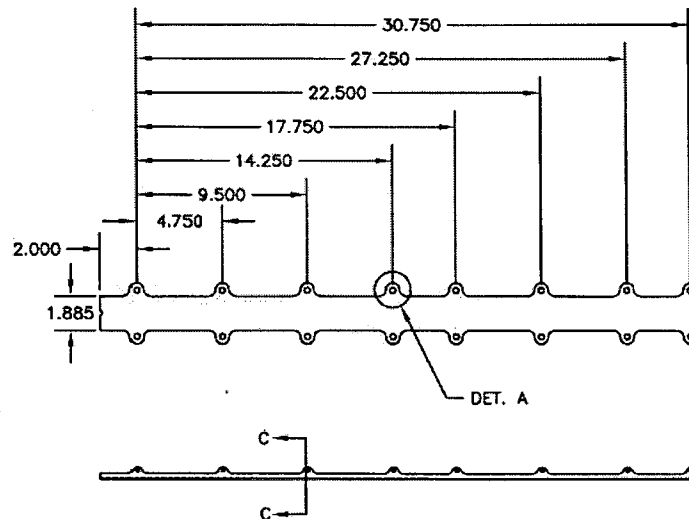
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<i>[Signature]</i>	<i>[Signature]</i>	D2656	SHEET 3 OF 4
DATE	TITLE	SCALE	
05.08.17	WEARSHOE	1:10	

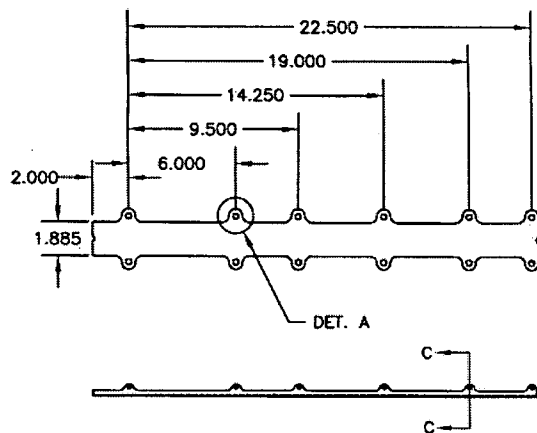
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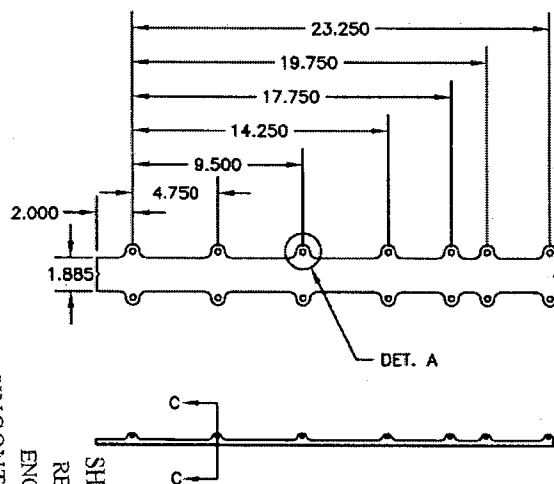
D2656-37



D2656-31



D2656-35



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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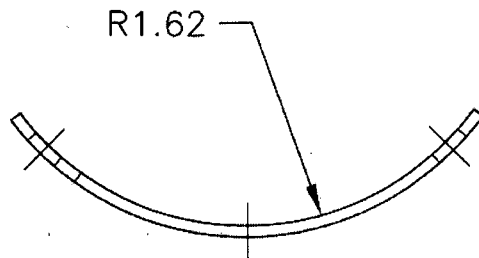
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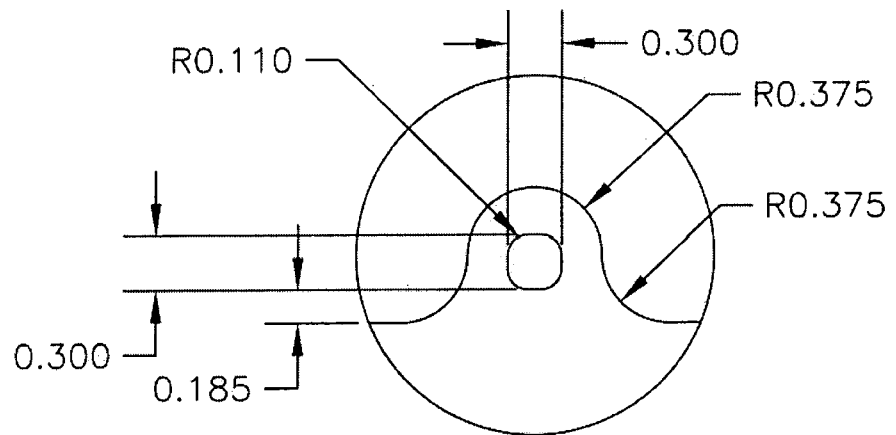
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

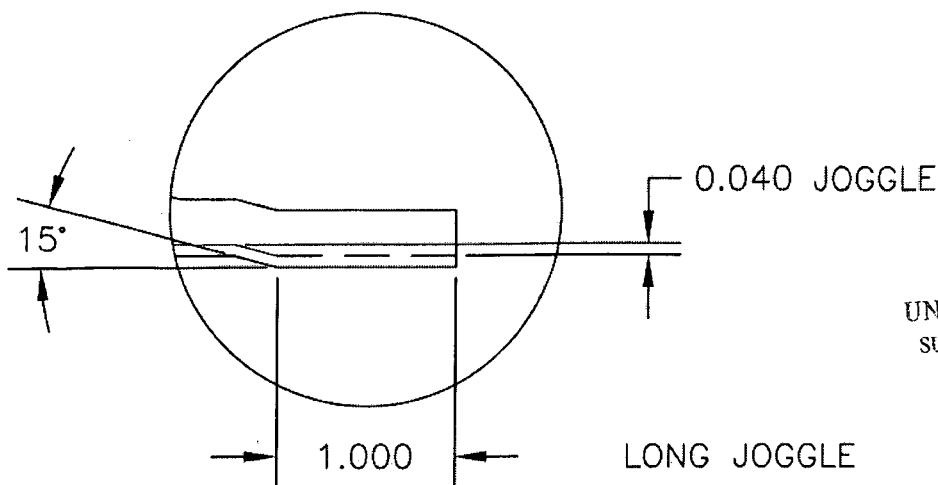


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DETAIL A



DETAIL B



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New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Wairakei
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5337/23317

CUSTOMER	Wilkinson	P50505DI002	SPECIFICATION	ASTMA1008 CS Type A	0.020	CERTIFICATE No	TC115838
CUSTOMER Q/N	90-21N-742		PRODUCT	CRA WIDE COIL		PAGE	1 of 1
MILL Q/N	486968		DIMENSIONS	0.033" x 48" x Coil		DATE	02 August 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)								
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND 180°	YIELD	T.S.	%ELONG G.L.=	HARDNESS HRB	r ()	LENGTH (feet)
		x100				x1000										x10000	x100							
R9-464817-00	844863	6	TR	20	7	17	15	23	14	2	3	1	3					Good				45		2618
R9-464818-00	844863	6	TR	20	7	17	15	23	14	2	3	1	3					Good				45		2664
R9-464819-00	779675	6	TR	20	14	16	11	21	13	2	3	1	3					Good				49		2618
R9-464820-00	779675	6	TR	20	14	16	11	21	13	2	3	1	3					Good				49		2825
R9-464821-00	779674	6	TR	21	13	17	13	22	17	2	3	1	3					Good				50		1923
R9-464822-00	779674	6	TR	21	13	17	13	22	17	2	3	1	3					Good				50		1978

W0405

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=0 (C)=45	(A)=10mm x 10mm	(A)=C+Mn/6
(B)=LOWER YIELD STRESS	(B)=50mm (D)=5.65 * So (F)=8"	(B)=90 (D)=(r+90+2*45) / 4	(B)=7.5mm x 10mm	(B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15
			(C)=5mm x 5mm	(C)=C+Mn/6+Si/24
			(D)=2.5mm x 10mm	(D)=
			(E)=5mm x 10mm	

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Batish Misra
QC METALLURGIST

P51020P002-80800

OCT-20-2005 15:06

OLBERT METAL SALES

905 795 1320

P.02

WILKINSON STEEL AND METALS

STAINLESS CR COIL 304
11 GA (111" X 48.0000")
PART NO.BL VA-000504-001 20Oct05
Pg 1/1

Certified in accordance to Pressure Equipment Directive 97/23/EC Annex L
Paragraph 4.3 by TÜV Aufagestechnik GmbH (Notified Body Identification No.0035)
Inspection Certificate EN10204-3.1B

**Shanxi Taigang Stainless Steel CO.,LTD Member
of Taiyuan Iron and Steel (Group) Co.,LTD**

NO.2 Jiancaoping, Taiyuan, Shanxi, P.R.China
TEL: (0351)3013328 FAX: (0351)3017816
http://www.tisco.com.cn
E-mail: tgbxg@tisco.com.cn

MILL TEST CERTIFICATE

MATERIAL	AISI304 No.2B Finish	
SPECIFICATION	ASTM A240/A480	ASME SA240/SA480
L/C NO.		
CERTIFICATE NO.	20030636	
DATE OF ISSUE	11	

CUSTOMER
OLBERT

CONTRACT NO.
1149

DATE OF
2005/06/20

Product	Making furnace	Inspector's stamp	Mark of the Manufacturer
COIL	E+VOD		Shanxi Taiyuan Stainless Steel Co., Ltd

NO.	Heat No.	Coil No.	Quantity	Dimensions	Weight (kg)
8	QBP1133	SA4-278-42B	1	20GA x 48 x C	8528
9	Y501898	SA4-419-42Y	1	14GA x 48 x C	5396
10	4501977	SA4-348-12B	1	11GA x 48 x C	5182
11	4501969	SA4-416-42Y	1	14GA x 48 x C	7709
12	4501968	SA4-415-42Y	1	14GA x 48 x C	7495
13	4501965	SA4-367-12B	1	11GA x 48 x C	8127
14	4500491	SA5-18-42J	1	20GA x 48 x C	7668

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
QBP1133	0.049	0.470	0.090	0.023	0.003	18.140	8.050				0.039
Y501898	0.058	0.430	0.090	0.029	0.004	18.430	8.070				0.066
4501977	0.070	0.470	1.310	0.019	0.002	18.050	8.100				0.050
4501969	0.030	0.430	1.270	0.018	0.002	18.020	8.010				0.050
4501968	0.060	0.460	1.350	0.018	0.003	18.120	8.100				0.050
4501965	0.050	0.440	1.320	0.019	0.002	18.140	8.090				0.050
4500491	0.050	0.500	1.340	0.020	0.002	18.040	8.000				0.050

Mechanical Properties

Test No.	Tensile R _m N/mm ²	R _{0.2} Yield N/mm ²	R _{0.01} Yield N/mm ²	Elongation A5%	Compression Tests	Hardness		
						HRB	HV	HRC
QBP1133-T	670	290		55			175	
Y501898-T	665	289		60		83		
4501977-T	615	279		60		86		
4501969-T	635	298		61		84		
4501968-T	650	294		58		84		
4501965-T	630	283		60		85		
4500491-T	660	329		60			172	

Surface and dimensions controlled: O.K.

Work Inspect

Page 2 of 3

